

Date: Thursday, 07/08/2008 9:21:24 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LOW GEAR SKIDTUBE ASSEMBLY 206 A/B
Job Number :	41044		
Estimate Number :	11972		
P.O. Number :		Part Number :	D206642141
This Issue :	07/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2650 REV E
First Issue :	/ /	Project Number :	N/A
Previous Run :	40424A	Drawing Revision :	E
	Type :	Material :	
	SKIDTUBES	Due Date :	22/08/2008
Written By :		Qty:	1 Um: Each
Checked & Approved By :	<i>JUL 08.8.07</i>		
Comment :	Est Rev:H 05.10.11 ECN 847 & 901; Add Tow Ring and GHW Kit; CHG004 KJ/CP/JLM Est Rev:I 08-06-10 chg D2654-3 to -1 (seq 13) DD verified by:ec Est Rev:J 08-07-14 remove QC5 at seq.41 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
		<i>KA for JUD 08.8.26</i> <i>Added ECN 08-556 08.11.07</i> <i>CHG003</i> <i>50914/05</i>
	Comment: DOCUMENT CONTROL	
	Photocopy bluefile & type labels per PPP D206-642-141	<i>CHG001</i>
2.0	D2620	Skidtube, 206 Skidtube
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	1 D2620 Bent Tube 3" OD <i>B40451</i>	<i>DP 8-8-7</i>
3.0	D32861	Doubler
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	2 D3286-1 Doubler <i>B40437</i>	<i>DP 8-8-7</i>
4.0	D2647	Cap
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	1 D2647 Fwd Cap <i>B35475</i>	<i>BE 8-8-7</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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5.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R

Aluminum Rod

m/07877/m108096 BE 8-8-7

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg 2650 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8166 (A,B & C).

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove and Deburr D3286-1 doubler

13-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

14-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

15-Remove indexing edge using DT8741 as per Dwg D2650

16-C'sink GHW rivet holes as per Dwg D2650

W/O:		WORK ORDER CHANGES					
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Seq. #:

Machine Or Operation:

Description :

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

8/8/7 (40)

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes as per Dwg D2650

DD 8-8-7

2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6.

8-11-3

3-Deburr tube and blow out chips from inside the tube

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

1 8-11-3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

2T 08-11-03

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-1 Drilling Detail (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

8-11-3

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

08-11-03 (1)

See new
FAI for
wear plate sig.
All is good.

12.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total: 52.0000 Each(s)

Pick:

Qty Part Number

Description Batch

52 CR3212-4-04 Rivet

54 8-11-3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D26541

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

batch:

B41267 ① M 8-11-3

14.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 8-11-3 Time: 3:55

Finish Date: 7 AM 08-11-04 Time: _____

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 m 109449

Sikaflex expire date: 8-11-30

M 8-11-3

15.0

QC5

INSPECT WORK TO CURRENT STEP



See

Comment: INSPECT WORK TO CURRENT STEP

16.0

D2649

Cross Bolt Spacer



Comment: Qty.: 17.0000 Each(s)/Unit Total: 17.0000 Each(s)

Pick:

Qty Part Number Description Batch

17 D2649 Crossbolt spacer B412632

① M 8-11-4

17.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-3 Spacer 41900

BE 8-11-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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Job Number: 41044

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

m109213 BE 08/04/04

2-Grind welds flush as per Dwg D2650.

M 8-11-5

3-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod

NONE BE 08/11/13

4-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr

M 8-11-13

19.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets

m109213 ② M 8-11-13

20.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 M7885/3-4-3 Rivets

106167 ② M 8-11-13

21.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041 Nut Plate

1534599 ① M 8-11-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

① H 8-11-13

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Counterbore work to Current Step. Inspect for foreign objects as per QSI 024

08-11-13 ①

24.0

QC8

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-11-13 ①

(P10)

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

FL 08/11/21 ①

26.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:15
320 OF
11:45

M-L 08/11/21

(1X)

27.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/11/24 ①

28.0

D26483

Wearpad



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D2648-3

Wearpad

DY2770

FL 08/11/24 ①

Dart Aerospace Ltd

W/O: 41044		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector
08-11-13	240	QC 10 required. Perm Change !!		08.11.27		 08-11-13	 08-11-13

Part No: D206-642-241 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 41044

Part Number: D206642141

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

D265611

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-11

Wearshoe

B35897

FL

30.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-21

Wearshoe

B38748

FL

31.0

D265631

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-31

Wearshoe

B41736

FL

32.0

D34291

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad

B41842

FL

33.0

ALS41032130

Insert



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

Pick:

Qty Part Number

Description Batch

42 ALS4-1032-130 Inserts

m105819

or (see QSI 017)

FL 08/11/24 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN960JD10L

Washer



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

42 AN960JD10L

Washer

m105793

FL

35.0

MS27039108

Screw



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

42 MS27039-1-08

Screw

m109061

FL

36.0

D26511

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D2651-1

Plugs

B41636 (x12) B41917 (x4)

FL

37.0

D26513

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D2651-3

O-Rings

B41124

FL

38.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 MS27039-4-06

Screw

m109061

FL

39.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN960JD416

Washer

m108161

FL 08/11/24 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Description :

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

Sikaflex expire date:

m109449
08/11

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153.

FX
08/11/24
①

41.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2646

Aft Cap

841435

FX.

42.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-1-08 Screw

m109061

FX.

43.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN960JD10L Washer

m105493

FX 08/11/24 ①

W/O:		WORK ORDER CHANGES					
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Description :

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 m109449

Sikaflex expire date: 08/11

2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4

Batch: m109917

FX 08/11/24 (1)

45.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/11/24 (1)

46.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

inspect for foreign objects as per QSI 024

08/11/24 (1)

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PP

42758

8/1/05

Seq

48.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/27 (1)

Job Completion



08/11/27

411044

W/O:		WORK ORDER CHANGES					
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DART

DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2650	REV. E SHEET 1 OF 5
DATE 06.03.30		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3	
E	06.03.30	RMV C'BORE, CHG DRILL, ADD CHAMFER	

RELEASED

16 04 17

Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

NOTES

- 1) WELD PER DART QSI 004
- 2) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 3) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 4) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 5) FINISH:
-CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 6) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

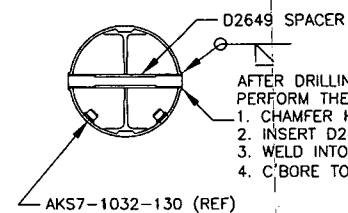
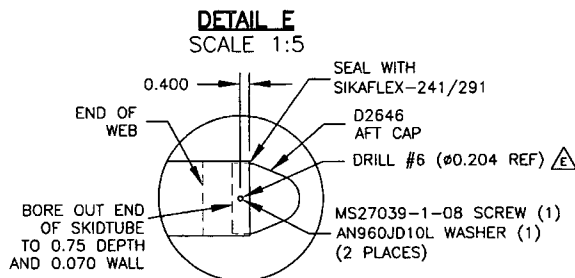
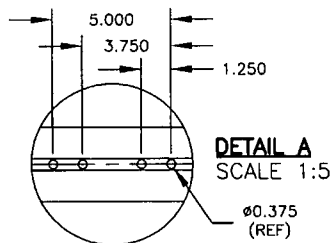
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



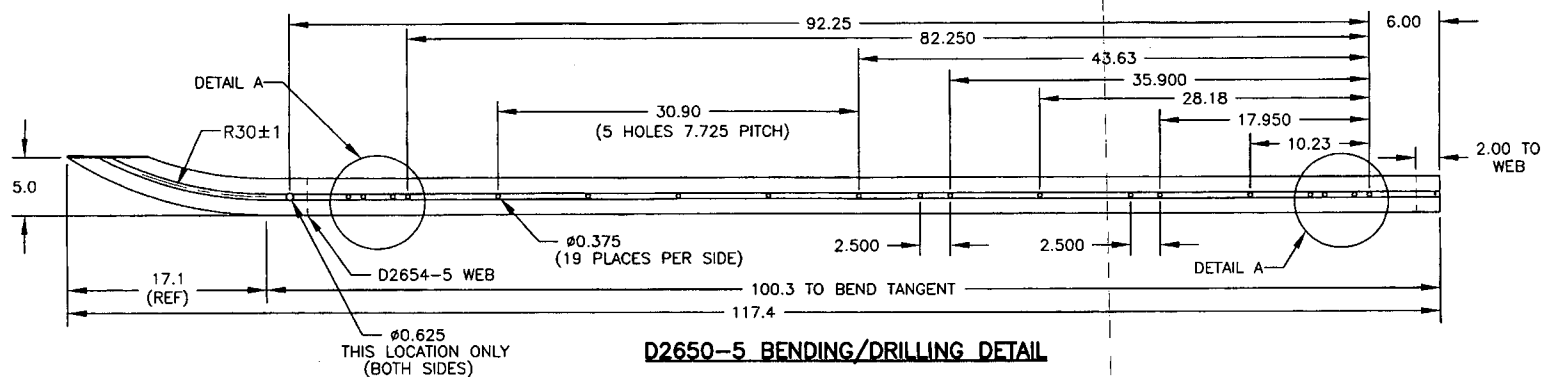
DETAIL D
FOR 0.375 HOLES ONLY

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375 HOLES ONLY:

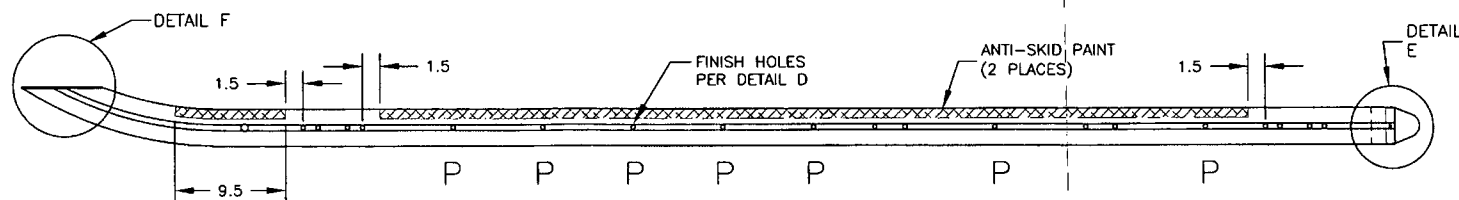
1. CHAMFER HOLE 0.030 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO 0.313 X 0.75 DEEP

RELEASED

06.03.30



D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

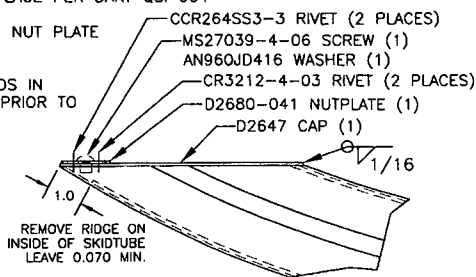
DETAIL F (NOT TO SCALE)

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN
D2680-041 PRIOR TO
FINISH



REMOVE RIDGE ON
INSIDE OF SKIDTUBE
LEAVE 0.070 MIN.



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DESIGN
CHECKED
DATE
06.03.30

DRAWN BY
APPROVED
DATE

DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA
DRAWING NO.
D2650
TITLE
SKIDTUBE
REV. E
SHEET 4 OF 5
SCALE
1:10

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WORK ORDER
NO. 21044

DART AEROSPACE LTD		Work Order: 41044
Description: PAR 08-02B	Part Number: 078028-1	
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
No dimensions		1.50"	✓		Vern	From AFT end.
are given on		5.00"	✓		Tape	
the dwg, but		9.75"	✓			
the interference		14.49"	✓			
issue has been		17.98"	✓			
resolved. 08-11-04		23.98"	✓			→ This was the affected area. Hole insert no longer interferes with the doubler.
		26.98"	✓			
		32.40"	✓			
		37.875"	✓			
		43.3125"	✓			
		48.765"	✓			
		54.23"	✓			
		59.61"	✓			
		62.625"	✓			
		68.26"	✓			
		71.76"	✓			
		76.00"	✓			
		80.25"	✓			
		83.74"	✓			
						Missing 3 most
						swel holes due to
						the band.

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 08-11-04	Date: 08/11/04	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	